

Date: Monday, 5/26/2008 1:09:56 PM
 User: Chantal Lavoie

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : PANEL-350 FWD CANOPY
Job Number : 39499	
Estimate Number : 13099	
P.O. Number :	Part Number : D36563
This Issue : 5/26/2008 S.O. No. :	Drawing Number : D3656 REV A
Prsht Rev. : NC	Project Number : 00204
First issue : / / Type : THERMOFORMING	Drawing Revision : A
Previous Run : 39498	Material :
Written By :	Due Date : 5/27/2008 Qty: 1 Um: Each
Checked & Approved By : <u>JLD 08.05.26</u>	
Comment : Est. Rev. A 07/12/13 DL verified by:DD	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	MLEXS093F600607	GE PLASTICS LEXAN SHEET
-----	-----------------	-------------------------



Comment: Qty.: 34.6600 sf(s)/Unit Total : 34.6600 sf(s)

GE PLASTICS LEXAN SHEET

batch: M107574 oh.

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
-----	----------------	------------------------------



Comment: HAND FINISHING THERMOFORMING

1) Cut Blanks to fit frame size

oh. 08.05.26

3.0	THERMOFORMING	THERMOFORMING MACHINE
-----	---------------	-----------------------



Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3656-3 and Folio FTA 016 using tool DT8987

Dwg. Rev. AFolio Rev. Aoh. 08.05.26

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

oh. 08.05.26
PTO-

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3656-3 PAR #: N/A Fault Category: Prod / Thermforming NCR: (Yes) No DQA: D Date: 08/05/07
 QA: N/C Closed: PP Date: 08/05/07

NCR: <u>39499</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.05.06</u>	<u>4</u>	<u>Did not form. Not hot enough.</u>	<u>[Signature]</u> <u>08/05/06</u>	<u>Scrap & Replace</u> <u>Qty 1 m. 107574</u>	<u>[Signature]</u> <u>08/05/06</u>	<u>[Signature]</u> <u>08/05/07</u>	<u>[Signature]</u> <u>08/05/07</u>	<u>[Signature]</u> <u>08/05/07</u>

NOTE: Date & initial all entries

Date: Monday, 5/26/2008 1:09:56 PM
User: Chantal Lavoie

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL-350 FWD CANOPY

Job Number: 39499

Part Number: D36563

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

BB 08/05/27 X1

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions as per dwg D3656

BB 08/05/27 X1

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 08/05/27 X1

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08-05-27 @

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FPP. 38502

AS 08/05/27

(X1)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/05/28

Job Completion



mf 08-05-27

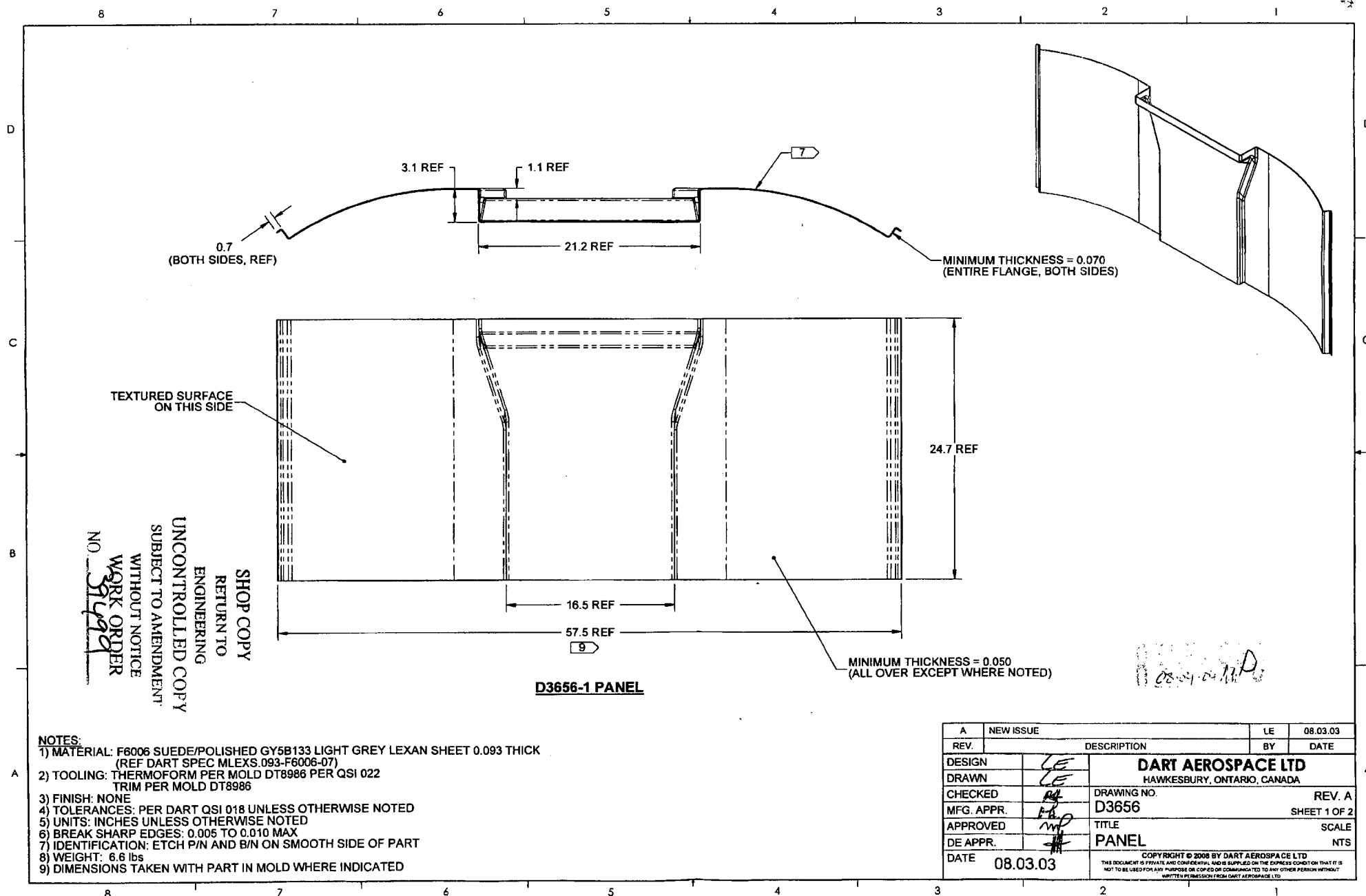
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

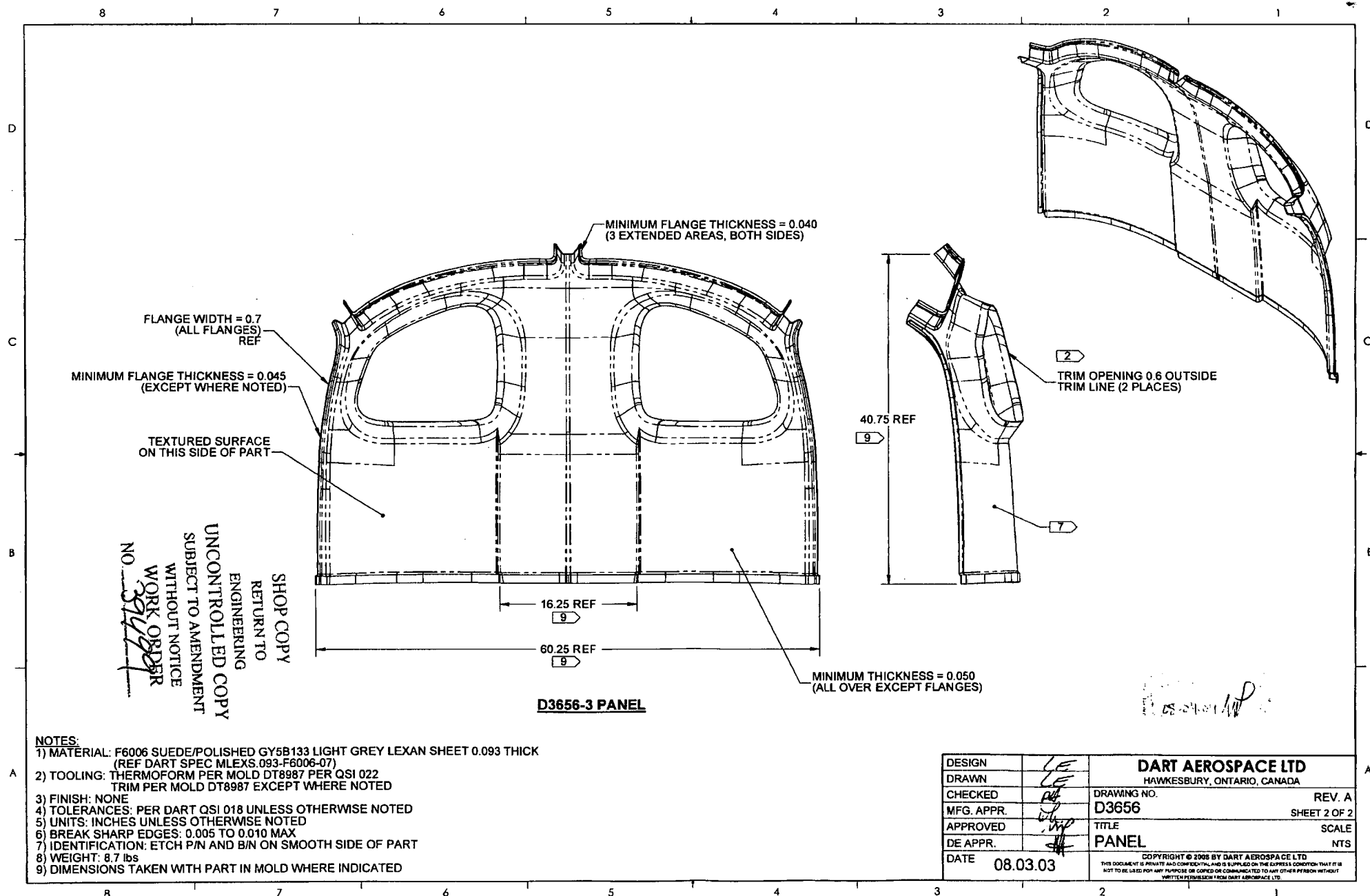
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries





DART AEROSPACE LTD	WORK ORDER:	39499
Description: Forward Canopy	Part Number:	D3656-3
Inspection Dwg: D3651 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

Description	Initials
Acceptable shape definition	<i>[Signature]</i>
Free of visual flaws (bumps, cracks, voids, etc.)	<i>[Signature]</i>

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing D3653 Rev. A and record below

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
40.75"	0.100"	40.75"	✓			
60.25"	0.100"	60.25"	✓			
D. 0.45" Thickness	Min	0.057"	✓			
0.40" Thickness	Min	0.057"	✓			

Measured by:	<i>[Signature]</i>
Date:	08.05.27

Audited by:	<i>[Signature]</i>
Date:	08/05/27

Prototype Approval:	<i>[Signature]</i>
Date:	

Rev	Date	Change	Revised by	Approved
		New Issue		

[Signature]